

Work Order ID 143789

March 22, 2016 4:22:17 PM

143789

Page 1

Item ID: E5375-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: ***NS2***
 Item Name: Plug Stop ***NS2***
 Start Date: 3/24/2016 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 4/1/2016 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: SA Date: 20160322 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
E5375	A								
110	FLOW WATER JET	0.00							
110									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89

APR 01 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

Work Order ID 143789

March 22, 2016 4:22:17 PM

143789

Page 2

Item ID:	E5375-7	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:					Stop	*NS2*
Item Name:	Plug					
Start Date:	3/24/2016	Start Qty: 8.00	*8*	Cust Item ID:		
Required Date:	4/1/2016	Req'd Qty: 8.00	*8*	Customer:		
Reference:						

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	*NR1*
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location:	0.00							
140									
Packaging	Memo	0.00				850		APR 01 2016	
Packaging								MAR 21 2016	
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.01							
Quality Control									
								MCS	APR 01 2016
								MF	16-48-01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause			FAULT CATEGORY			
Environment ☐		No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐		Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐		Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐		Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐		Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐		Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐		Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐		Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐		Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐		Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐		Manufacturing Process ☐	OTHER : ☐			
Misidentified ☐		Past Due ☐				

Picklist Print

March 22, 2016 4:22:22 PM

Page 1

Work Order ID: 143789

143789

Parent Item: E5375-7

F5375-7

Parent Item Name: Plug

Start Date: 3/24/2016

Required Date: 4/1/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 16.02.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased		No			sf	345.8730		2.105263			

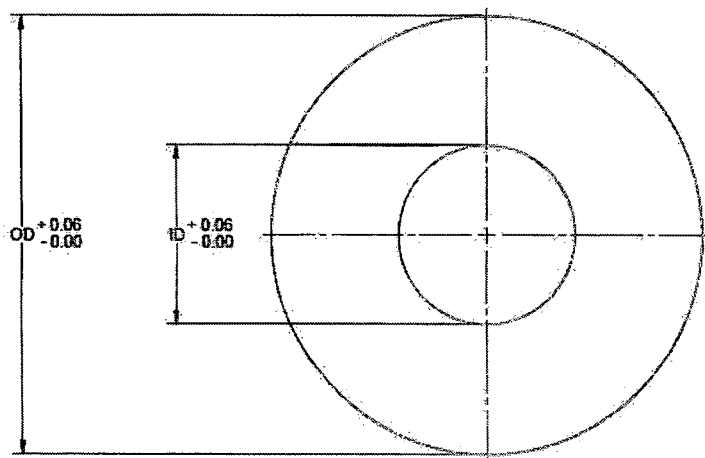
MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

OK 16/03/31

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	168.9	
m134171	168.9	
MAT018	176.973	
m131661	1.473	
m134372	175.5	

2.2



PART NUMBER	OD (INCHES)	ID (INCHES)	T (INCHES)	MATERIAL	WEIGHT (LBS)
E5375-1	4.25	2.00	1.00	SEE NOTE 1	0.56
E5375-3	4.50	2.00	1.00	SEE NOTE 1	0.65
E5375-5	5.50	2.25	1.00	SEE NOTE 1	1.01

E5375-X PLUG

NOTES:

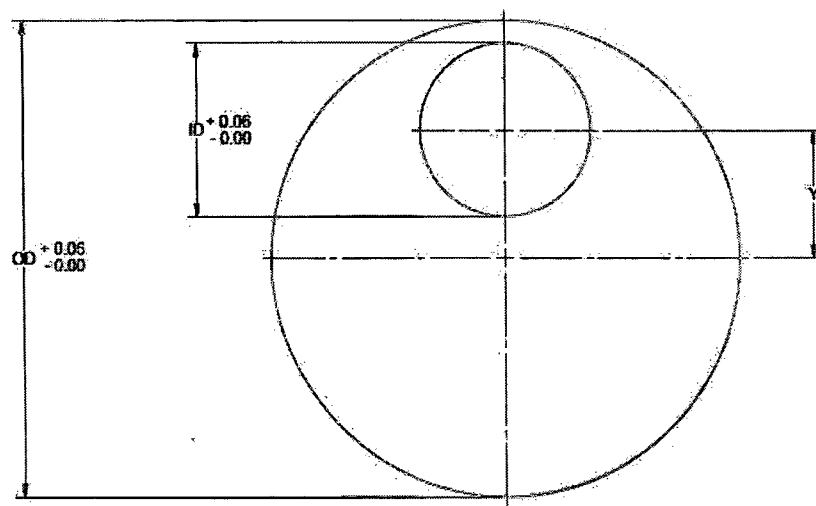
- 1) MATERIAL: 1.000" THICK DELRIN II 150E
PER DART SPEC M-DELIN-S1.000
OR 1.000" THICK UHMW BLACK TIVAR 1000
PER DART SPEC MUHMWB100
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "E5375-X" PER DART QSI 044, SECTION 6.1
- 7) WEIGHT: SEE TABLE
- 8) NO ARC REQUIRED

RELEASED
2016-02-16
ECW16-519

20160322
SH 143789

A	ISSUE	CC	15.12.09
REV.	DESCRIPTION		BY DATE
DESIGN	CC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CC		
CHECKED	RF		DRAWING NO. REV.
MFG. APPR.	JLM		E5375 SHEET 1 OF
APPROVED	HS		TITLE SCALE
DE APPR.	N/A		PLUG NTS
DATE	15.12.09		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUBJECT TO THE EXPIRING COPYRIGHT THEREIN. NOT TO BE REPRODUCED FOR ANY PURPOSE OR REPRODUCED OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.

COPYRIGHT © 2015 BY DART AEROSPACE LTD.
THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



PART NUMBER	OD (INCHES)	ID (INCHES)	Y (INCHES)	T (INCHES)	MATERIAL	WEIGHT (LBS)
E5375-7	6.00	2.19	1.68	1.00	SEE NOTE 1	0.56

E5375-X PLUG

NOTES:

- 1) MATERIAL: 1.000" THICK DELRIN II 150E
PER DART SPEC M-DELRIN-S1.000
OR 1.000" THICK UHMW BLACK TIVAR 1000
PER DART SPEC MUHMBW100
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "E5375-X" PER DART QSI 044, SECTION 6.1
- 7) WEIGHT: SEE TABLE
- 8) NO ARC REQUIRED FOR THIS PART

RELEASED
2016-02-16
JEN 16-517

A		ISSUE	CC	15.12.08
REV.	DESCRIPTION			BY DATE
DESIGN	CC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	CC			
CHECKED	RF	DRAWING NO.	REV. /	
MFG. APPR.	JLM	E5375	SHEET 2 OF 2	
APPROVED	HS	TITLE	SCALE	
DE APPR.	N/A	PLUG	NTS	
DATE	15.12.09		COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR DISCLOSED TO ANY OTHER PERSON OR ENTITY. DART AEROSPACE LTD	

